

Work Order ID 67552

Monday, March 28, 2011 10:20:28 AM



Page 1

Item ID:	D4038-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Angle Assembly, Aft, LH				Stop	
Start Date:	3/28/2011	Start Qty: 300 <i>mf</i>		Cust Item ID:		
Required Date:	4/5/2011	Req'd Qty: 200		Customer:		
Reference:						

Approvals:	Process Plan: <i>mf</i>	Date: 11-03-28	Tooling:		Date:		Run	Start	
	QC:	Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4038	D

100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

110		0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								

SB 11/04/04

7m-l 11/04/04

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8 11/04/04

-043

mf

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67552

Monday, March 28, 2011 10:20:28 AM



Page 2

Item ID: D4038-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Assembly, Aft, LH

Start Date: 3/28/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 115

0.00



Packaging

Memo

0.00

Packaging

11/4/11/5

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11/5

MF

11-04-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 10:20:23 AM

Page 1

Work Order ID: 67552

Parent Item: D4038-043

Parent Item Name: Angle Assembly, Aft, LH











Start Date: 3/28/2011 .

Required Date: 4/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP
Rev:B 11.01.31 as per dwg rev.c DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4038-3 		Manufactured	No			100	Each	0.0000	1	2			
Angle, Aft, LH						B 67565				SB 11/04/04			③
D4038-7 		Manufactured	No			100	Each	0.0000	1	2			
Block						B 67566				SB 11/04/04			③
D4038-11 		Manufactured	No			100	Each	0.0000	1	2			
Block						B 67564				SB 11/04/04			③
AN3-14A 		Purchased	No			100	Each	50.0000	2	4			
Bolt										SB 11/04/04			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		50							
				116978		50							
MS21042L3 		Purchased	No			100	Each	2,223.000	2	4			
Nut										SB 11/04/04			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST300		2223							
				116391		623							
				116540		800							
				116549		800							

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 10:20:23 AM

Page 2

Work Order ID: 67552



Parent Item: D4038-043



Parent Item Name: Angle Assembly, Aft, LH

Start Date: 3/28/2011

Required Date: 4/5/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

100

Each

2,080.000

4

8



Washer

SB 11/04/04

Location

Loc Qty

Loc Code

ST298

2080

116583

2080

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

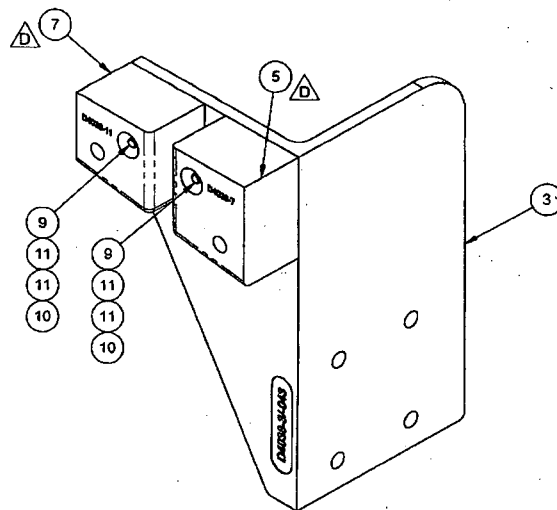
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

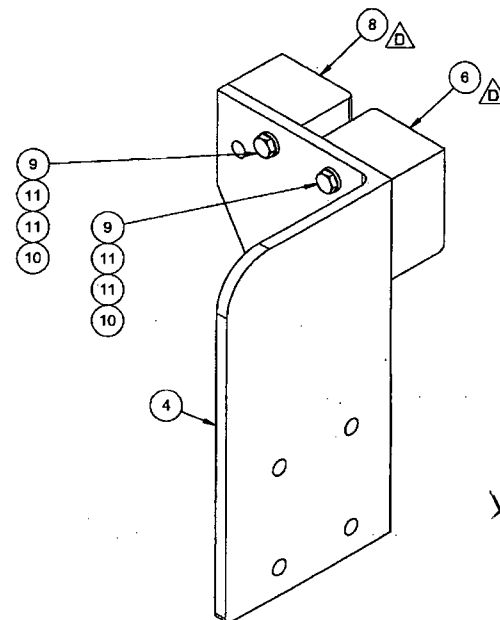
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X		D4038-043	ANGLE ASSEMBLY, AFT, LH
2		X	D4038-044	ANGLE ASSEMBLY, AFT, RH
3	1		D4038-3	ANGLE, AFT, LH
4		1	D4038-4	ANGLE, AFT, RH
5	1		D4038-7	BLOCK
6		1	D4038-8	BLOCK
7	1		D4038-11	BLOCK
8		1	D4038-12	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)



D4038-043 ANGLE ASSEMBLY, AFT, LH



D4038-044 ANGLE ASSEMBLY, AFT, RH

#67550

RELEASED
2011-03-07
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -043 - 1.97 lbs
-044 - 1.96 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. D
MFG. APPR.		D4038 SHEET 2 OF 14
APPROVED		TITLE SCALE
DE APPR.		BRACKET NTS
DATE	11.03.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD

THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries